

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job Number	: 35836		
Estimate Number	: 10467		
P.O. Number	:	Part Number	: D3391021
This Issue	: 11/19/2007 S.O. No. :	Drawing Number	: D3391 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: G
Previous Run	: 35835	Material	:
Written By	: <u>[Signature]</u>	Due Date	: 12/10/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. A 05.09.13 New issue KJ/JLM		
	: Est. B 06.02.10 Dwg rev.D ecn 773 EC		
	: Est. C 06.05.02 Added inspections EC		
	: est D 07.03.13 rev F dwg EC		
	: est E 07.11.07 revG dwg ecn1053P EC verified by: DD		
	: Est Rev:f ECN 1056 07-11-12 DD verified by: EC		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6013047	SKIDTUBE MAT'L
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	B2

Batch B26547 DP 7-11-20

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut extrusion to 46.52 +0.010 -0.020

7-11-20

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: Nc bender

Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-11-26

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

6 7/11/24

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. 1 & Dwg D3391 Rev. 3  
Identify as D3391-1

SA 01.12.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:03:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 35836

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Debur

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 01.12.03

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.12.04 (1)

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.12.04 (2)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT,8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Debur & Scribe Batch number Inside aft end.

DP  
7-12-5

DP  
7-12-12

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07.12.04 (4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/19/2007 4:03:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 35836

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DP 8-1-9

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 08-01-15

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER B35813

batch: M106695

2008/2/22  
DP 8-1-15

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

instal spacers as per dwg D3391

up 9-5-1

A/R Magnabond 6398

batch: M106695

DP 8-1-15

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/22 (X)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107005

HL 08-02-26 (X)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/30 (D)

19.0

ALS41032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

batch: M105819

or equivalent

per QSI 017

FL 08/07/30 (D)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:03:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 35836

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

INSERT

batch: m/100489

or equivalent

per QSI 017

FL

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

FL 08/07/30 ①

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/30

23.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty	Part Number	Description	Batch
1	D3401-041	Tow Cap	<u>B36216</u>

FL

24.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B39791

FL

25.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

B39574

FL

26.0

D36721

PHENOLIC WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PHENOLIC WASHER

B39275

FL 08/07/30 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 11/19/2007 4:03:00 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 35836

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN3C4A

Bolt

M108599

FX

28.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

M108672

FX

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

FX 08/07/30  
①

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8821

8/7/30

FX 08/07/30  
①

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 39103

5/8/15

②

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/19

Job Completion



MF 08-08-19

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

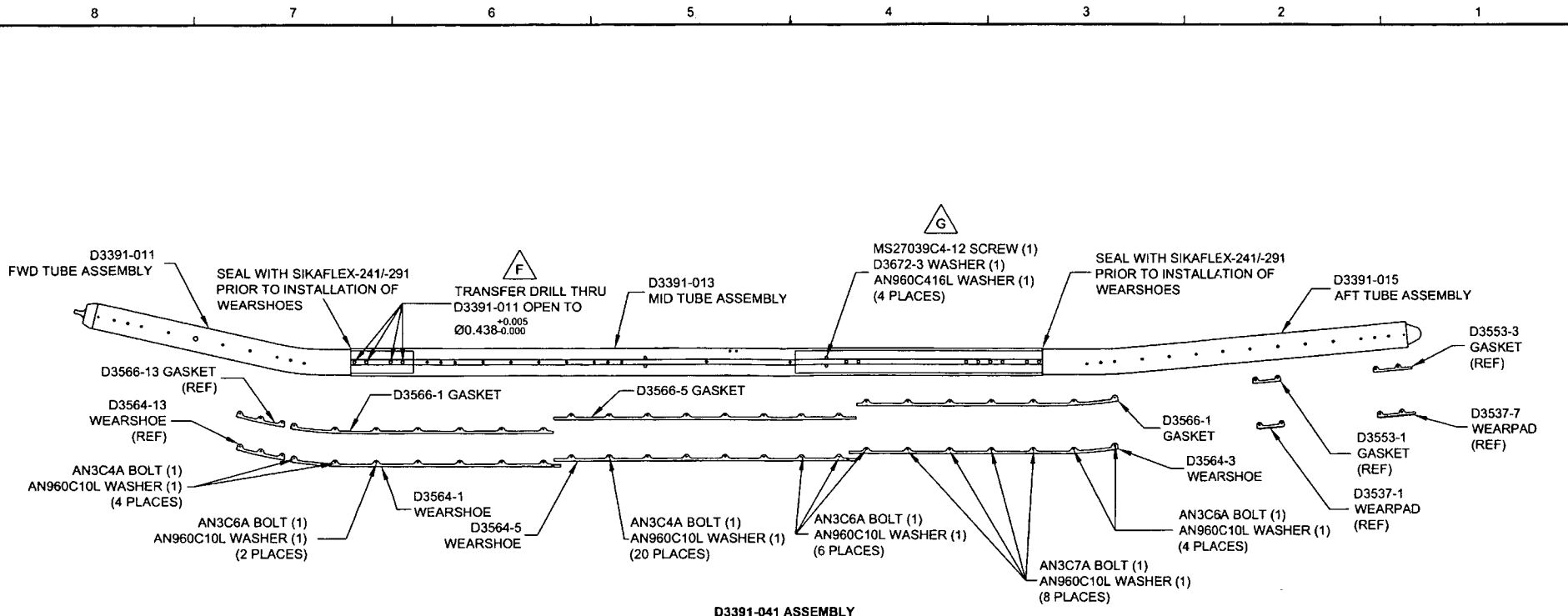
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





**D3391-041 ASSEMBLY**

RELEASED  
07-11-87

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

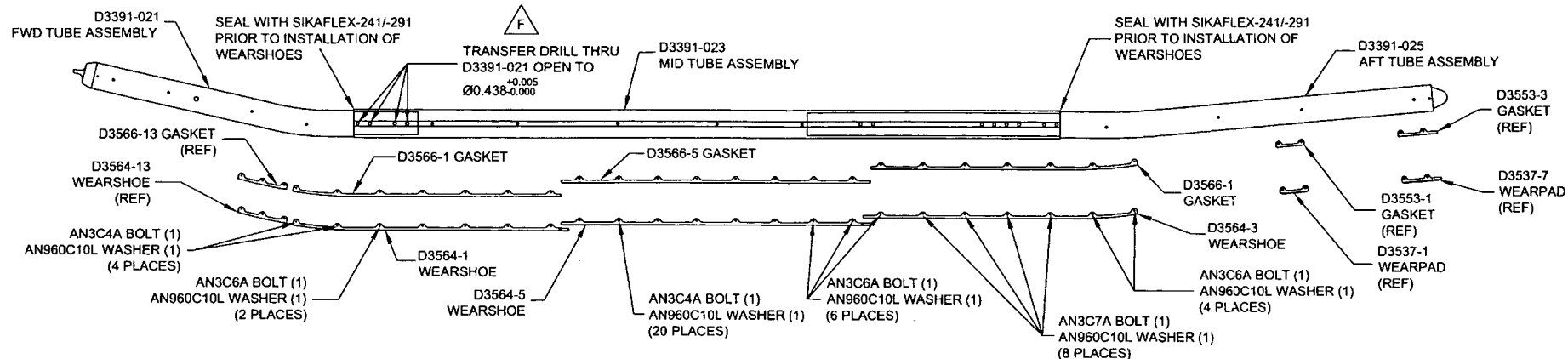
QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

NO. 30836  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		
<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA DRAWING NO. D3391 TITLE 412 FLOAT SKIDTUBE SCALE NTS REV. G SHEET 1 OF 8 COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



**D3391-043 ASSEMBLY**

RELEASED  
07.11.94

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

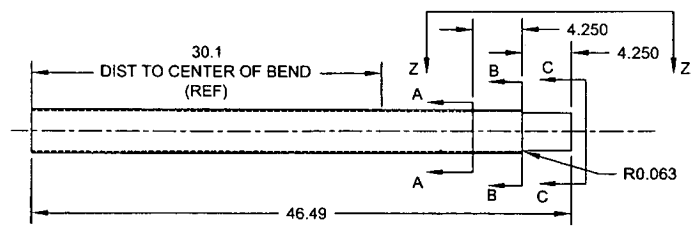
QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

**GENERAL NOTES**

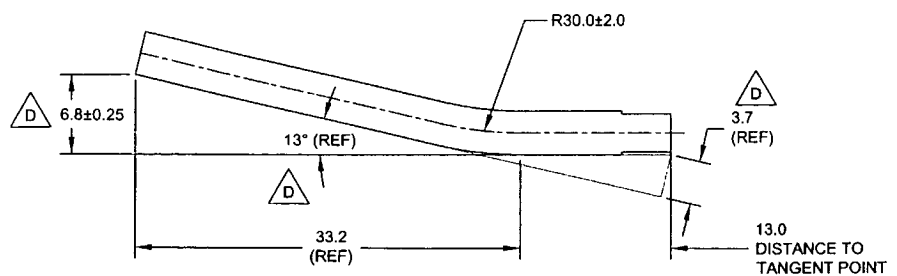
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

NO. 35836  
WORK ORDER  
SUBJECT TO AGREEMENT  
UNCONTROLLED COPY  
ENGINEERING COPY  
RETURN TO  
SHOP COPY

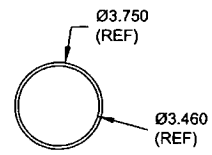
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	JJC	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. G
MFG. APPR.	JP	D3391	SHEET 2 OF 8
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



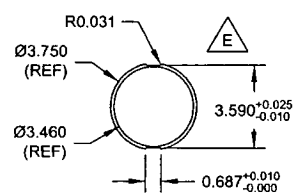
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



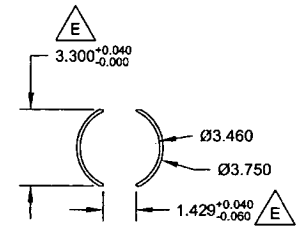
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



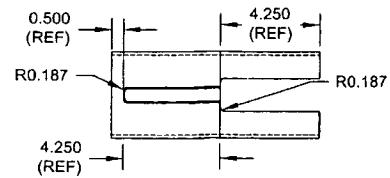
**SECTION A-A**  
(SCALE 1:5)



**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)



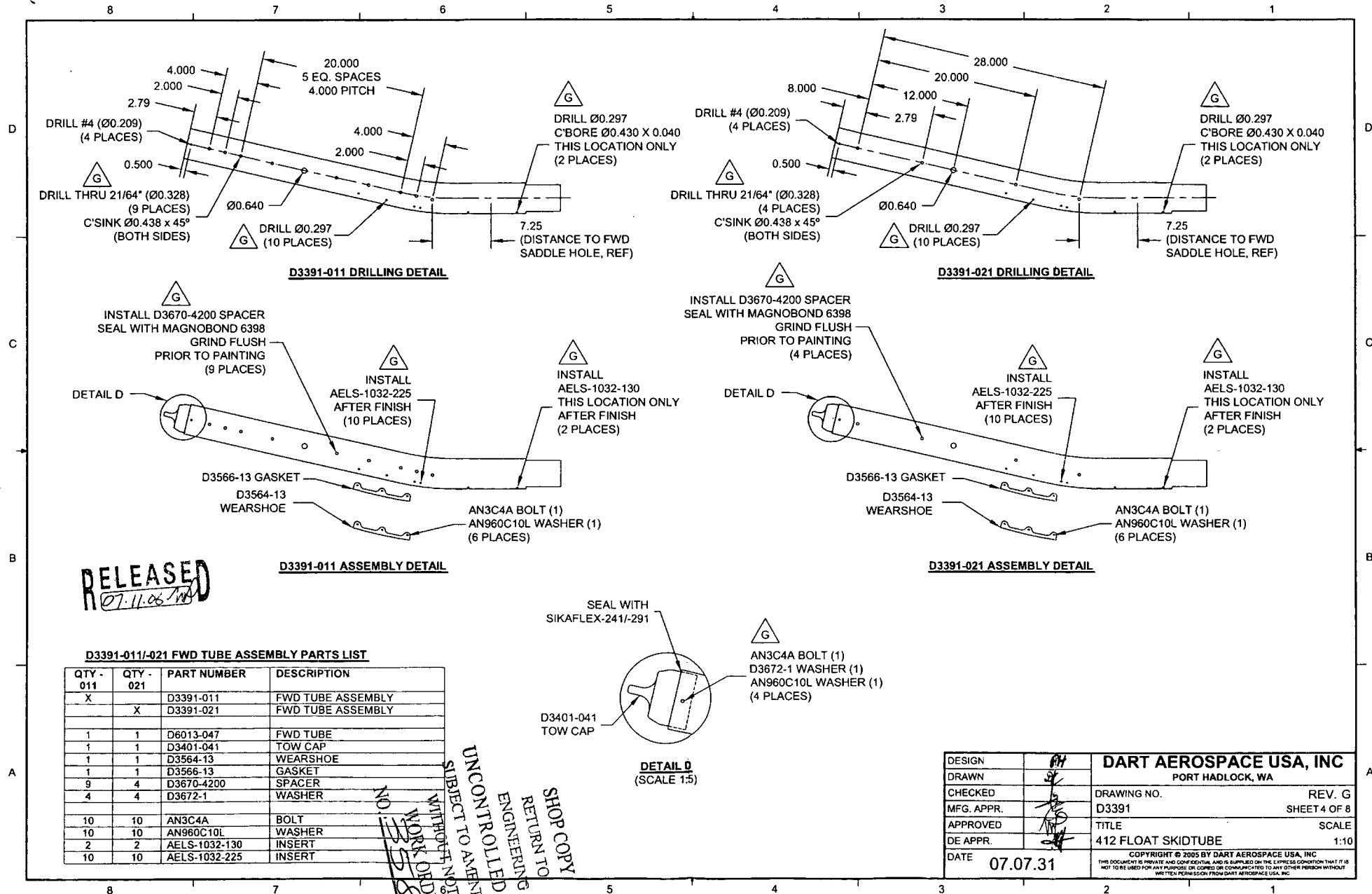
**VIEW Z-Z**  
(SCALE 1:5)

RELEASED  
07-11-2017

NO. 35836  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:10
DATE	07.07.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



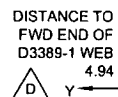


RELEASED  
07.11.06

NO. 135836  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

DESIGN	07	DART AEROSPACE USA, INC	
DRAWN	07	PORT HADLOCK, WA	
CHECKED	07	DRAWING NO.	REV. G
MFG. APPR.	07	D3391	SHEET 4 OF 8
APPROVED	07	TITLE	SCALE
DE APPR.	07	412 FLOAT SKIDTUBE	1:10
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	






DRILL THRU 21/64" (Ø0.328)  
C'SINK Ø0.438 X 45° (BOTH SIDES)  
(12 PLACES)



**D3391-013 ASSEMBLY DETAIL**



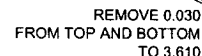
Y  DISTANCE TO  
END OF WEB  
4.19  
(REF)




INSTALL  
D3681-1 SPACER



△



 DRILL Ø0.297  
INSTALL AELS-1032-130 INSERT  
MS27039C1-09 SCREW  
D3672-1 WASHER  
AN960C10L WASHER  
AFTER FINISH  
(TYP 4 PLACES)

~~6~~

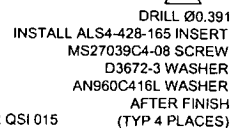
DRILL Ø0.250  
(TYP 4 PLACES)

QTY -013	PART NUMBER	DESCRIPTION
X	Q3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



18°  
(TYP)

**SECTION LL-LL**  
(SCALE 1:4)



18°  
(TYP)

RELEASE

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	DF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. 0
MFG. APPR.		D3391	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	1:2
DATE 07.07.31		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE PROPERTY OF DART AEROSPACE USA, INC AND IS SUPPLIED ON THE BASIS OF CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPLETELY COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

### D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC

